

Work Order ID 142356

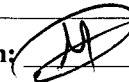
142356

Page 1

Monday, March 07, 2016 4:05:41 PM

Item ID: D5371-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hook
 Start Date: 3/11/2016 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 3/16/2016 Req'd Qty: 3.00 *3* Customer:

Reference:

Approvals: Process Plan:  Date: 16-3-7 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5371	A

100	BAND SAW	0.00				3	0		DAS 08 9-89
100		0.00	B.A	16/03/22					
Bandsaw	Memo								
Jeaspa Bandsaw	Cut Blanks at 3.250"								

110	HAAS CNC VERTICAL MACHINING #1	0.00				3	0		DAS 08 9-89
110		0.03	B.A	16/03/22					
HAAS 5AXIS	Memo								
HAAS CNC vertical machine #5	1-Machine 1st op as per folio FB446								
	DWG REV: A								
	FOLIO REV: AA								

2- deburr and break all sharp edge as per dwg

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER : _____							
Misidentified	☐	Past Due								

Monday, March 07, 2016 4:05:41 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

3

3

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

115

Memo

HAAS 1

HAAS CNC vertical machine #1

1-Machine 2nd op as per folio FB446
DWG REV: A
FOLIO REV: AA

0.00

0.01

B.A 16/03/23

(2)

④

DAS
08
0.20

2- deburr and break all sharp edge as per dwg

120

QC2- Inspect parts off machine FAI/FAIB

0.00

D. 16/03/23

11

Q

DAS
08
9-89

Memo

QC

Quality Control

0.00

130

QC8- Inspect parts - second check

0.00

Memo

QC

Quality Control

0.00

3

4

DAS
44
9-89 16/03/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																												
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<table style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="2" style="text-align: left;">Root Cause</th> <th colspan="4" style="text-align: left;">FAULT CATEGORY</th> </tr> <tr> <td style="width: 15%;">Environment ☐</td> <td style="width: 15%;">No Re-verification ☐</td> <td style="width: 15%;">Pressure/Forced ☐</td> <td style="width: 15%;">Temperature/Cure ☐</td> <td style="width: 15%;">Power Loss/Surge ☐</td> <td style="width: 15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="4" rowspan="2" style="text-align: center; vertical-align: top;">OTHER : ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>					Root Cause		FAULT CATEGORY				Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐				Misidentified ☐	Past Due ☐
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Work Order ID 142356

Monday, March 07, 2016 4:05:41 PM

142356

Page 4

Item ID: D5371-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hook

Start Date: 3/11/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 3/16/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location <u>5t/63</u>	0.00				<u>3</u>	<u>0.06</u>		
180						<u>6</u>	<u>0.00</u>		<u>MAR 24 2016</u>
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190						<u>ML5</u>			<u>MAR 24 2016</u>
QC	Memo	0.01							
Quality Control									

ML5 **MAR 24 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
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LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Monday, March 07, 2016 4:05:45 PM

Page 1

Work Order ID: 142356

142356

Parent Item: D5371-2

D5371-2

Parent Item Name: Hook

Start Date: 3/11/2016

Required Date: 3/16/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV.A NEW ISSUE JFS 15/12/14 VERIFIED BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X06.00 0		Purchased	No			100	f	18.0770	0.271	0.855789			

M6061T6B1 000X06 000

6061T6 BAR 1.00 X 6.00

16/03/22

Location

Loc Qty

Loc Code

MAT003

18.077

m125771

0.53

m127797

5.92

m129530

2.92

m129639

4.67

m130013

1.42

→ m133888

2.617

0.916 ft

DQA: _____ Date: _____

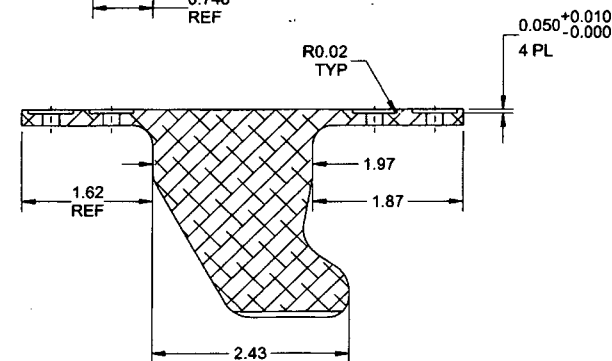
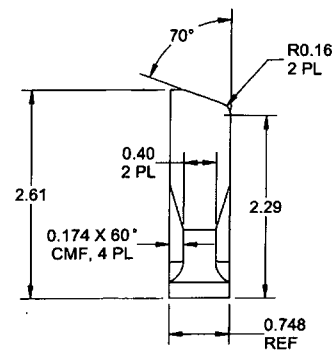
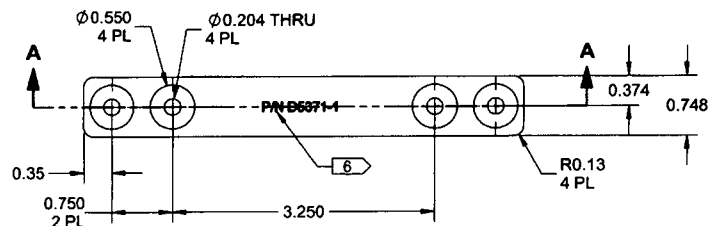
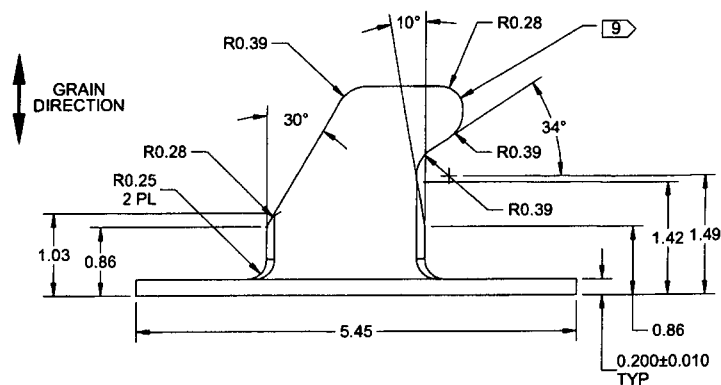


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
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Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								



D5371-1 HOOK

SECTION A-A

NOTES:

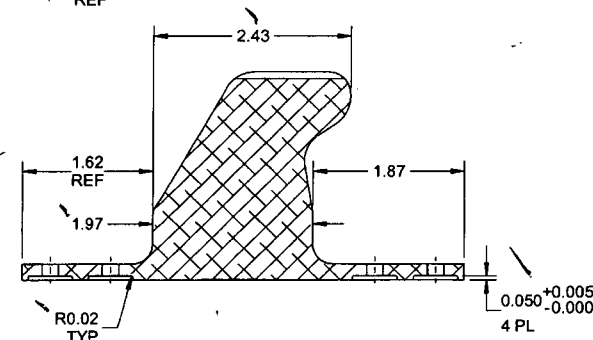
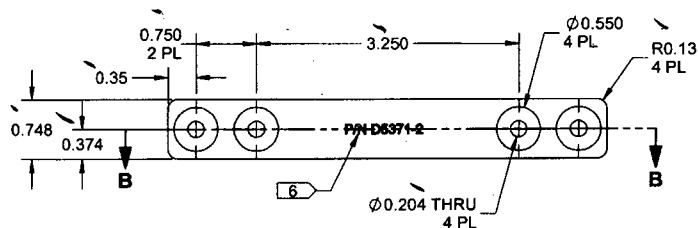
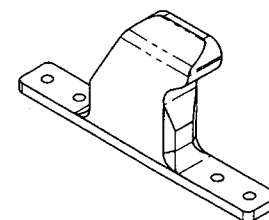
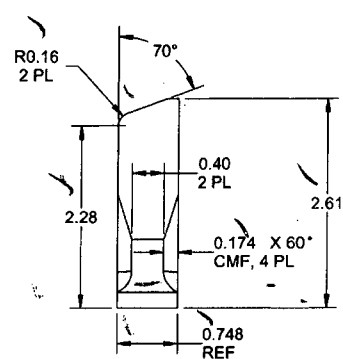
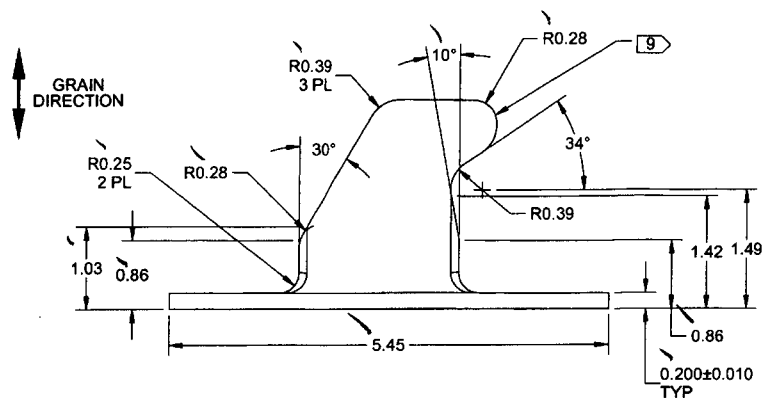
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK GLOSS" (4.3.5.13) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3
- 7) WEIGHT: 0.36 lbs
- 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5371-1 Rev. A.SLDPRT
- 9) BREAK EDGES OF HOOK PROFILE 0.050 MINIMUM

Handwritten: 16-3-T
142356

RELEASED
2016-01-21
E2N IL-510

APPROVED

A NEW ISSUE		RF	15.12.03
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5371	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	HOOK	NT
DATE	15.12.03	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D5371-2 HOOK

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221.
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK GLOSS" (4.3.5.13) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3
- 7) WEIGHT: 0.36 lbs
- 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5371-2 Rev. A.SLDPR
- 9) BREAK EDGES OF HOOK PROFILE 0.050 MINIMUM

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5371	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	HOOK	NTS
DATE	15.12.03	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED
17-10-9102
RELEASED

DART AEROSPACE LTD		Work Order:	142356
Description: HOOK		Part Number:	D5371-2
Inspection Dwg: D5371 Rev: A		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.45	+/-0.030	5.449	✓		Vern	GA-13
R0.25	+/-0.030	R0.250	✓		R-6	ref.
R0.28	+/-0.030	R0.281	✓		"	"
30°	+/- 1/2°	30°	✓		Angle M.	CNC-17
R0.39	+/-0.030	R0.391	✓		R-6	ref.
10°	+/- 1/2°	10°	✓		Angle M.	CNC-17
R0.28	+/-0.030	R0.281	✓		R-6	ref.
34°	+/- 1/2°	34°	✓		Angle M.	CNC-17
R0.39	+/-0.030	R0.391	✓		R-6	ref.
0.86	+/-0.030	0.865	✓		Vern	GA-13
0.200	+/-0.010	0.200	✓		"	"
2.28	+/-0.030	2.278	✓		"	"
R0.16	+/-0.030	R0.156	✓		R-6	ref.
70°	+/- 1/2°	70°	✓		Angle M.	CNC-17
0.40	+/-0.030	0.398	✓		Vern	GA-13
2.61	+/-0.030	2.609	✓		"	"
0.174 x 60°	+/-0.010 / +/- 1/2°	0.176 x 60°	✓		"	"
φ0.204	+0.005 / -0.001	φ0.205	✓		"	"
0.374	+/-0.010	0.375	✓		"	"
0.748	+/-0.010	0.750	✓		"	"
0.35	+/-0.030	0.350	✓		"	"
0.750	+/-0.005	0.750	✓		"	"
3.250	+/-0.005	3.250	✓		"	"
φ0.550	+/-0.010	φ0.552	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-6	ref.
R0.02	+/-0.030	R0.015	✓		"	"
1.97	+/-0.030	1.968	✓		Vern	GA-13
2.43	+/-0.030	2.427	✓		H-6	31006
1.87	+/-0.030	1.868	✓		"	"
0.050	+0.005 / -0.000	0.054	✓		D-6	GA-08

DAS

Measured by: HA	DAS 08 9-89	Checked by: 44	QC Inspector:
Date: 16/03/22		Date: 16/03/23	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	